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Hawkesbury, ON
K6A 1K7
Canada

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005437

D500-572-011
Job Sheet 183114



Part No: D500-572-011

Job Qty: 2 ea

Part Name: MD369/MD500 Bearpaws



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/12/18

Job Tracking No:

Due Date: 9/17/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG IIND500-572 REV A, DSI 9770 REV A IPP Rev:C 04.02.17 Blank size changed KJ/JLM IPP Rev:D 07-01-02 Was K10007 JLM IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	9/17/18	9/17/18	0.00	0.00	Start Up Stores/Pkg-2		SEP 13 2018
160	Packaging	2 pcs	9/17/18	9/17/18	0.00	0.00	Packaging1-5		SEP 13 2018
170	QC	2 pcs	9/17/18	9/17/18	0.00	0.00	QC4		SEP 13 2018
180	Packaging	2 pcs	9/17/18	9/17/18	0.00	0.00	Packaging3-2		SEP 13 2018
185	DC	2 pcs	9/17/18	9/17/18	0.00	0.00	DC		SEP 13 2018
190	QC21-FG	2 Ea	9/17/18	9/17/18	0.00	0.00	QC21		SEP 13 2018

Part Op 180 - Identify and pack for shipping as per PPPD500-572-011

Descriptions: 185 - Photocopy bluefile and create labels per PPP D500-572-011 CHG006

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-13A	Bolt	16 Ea (8 ea)	90-Start up Operation	5089302
D2274	Radius Block	16 Ea (8 ea)	90-Start up Operation	5097635
D2435	Bearpaw	4 Ea (2 ea)	90-Start up Operation	5097057
D2529	Washer	16 Ea (8 ea)	90-Start up Operation	5035098
D5472-1	Cushion	8 Ea (4 ea)	90-Start up Operation	5160782
D5476-1	Clamp	8 Ea (4 ea)	90-Start up Operation	5050483x4, 5084783x4
MS21042L4	Nut	16 Ea (8 ea)	90-Start up Operation	5022425x13, 5046632x
NAS1149D0463J	Washer	16 Ea (8 ea)	90-Start up Operation	5089299
QS200-M44S	Clamp	4 Ea (2 ea)	90-Start up Operation	5048406

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-13A	16	956	0
	D2274	16	242	0
	D2435	4	8	0
	D2529	16	1,129	0
	D5472-1	8	152	0
	D5476-1	8	24	0
	MS21042L4	16	4,220	0
	NAS1149D0463J	16	7,486	0
	QS200-M44S	4	44	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ _____ _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐	Engineering ☐ Quality ☐ Other ☐																																																																														
Part: D500-572-011 Job No: 183114 Serial No/Batch: S109815 Revision: Inspector: Exp Date: Instructions: TC STC SH90 - 17 Issue 7aafAbiRTG SH849NE DART AEROSPACE Container No: S109815 1270 Aberdeen Street Hawkebury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com					MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																														
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Root</td> <td style="width:15%;"></td> <td style="width:15%;"></td> <td style="width:15%;"></td> <td style="width:15%;"></td> <td style="width:15%;"></td> </tr> <tr> <td>Environment</td> <td>☐</td> <td></td> <td></td> <td></td> <td>Power Loss/Surge</td> </tr> <tr> <td>Design</td> <td>☐</td> <td></td> <td></td> <td></td> <td>Folio/Program</td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td></td> <td></td> <td></td> <td>Grain</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> <td>☐</td> <td>Cracks</td> <td>Weld</td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> <td>☐</td> <td>Crimp/Kink/Ripple/Wave</td> <td>Wrong Stock Pulled</td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Testing</td> <td>☐</td> <td>Cuffs</td> <td>Out of Sequence</td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> <td>Crushing</td> <td>Off-set</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> <td>Heat Treat</td> <td>Mislabeled</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> <td>Wave/Twist in Tube</td> <td>Fit/Function</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> <td>Marks/Chatter</td> <td>Misaligned/off center</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> <td></td> <td></td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> <td>OTHER :</td> <td></td> </tr> </table>						Root						Environment	☐				Power Loss/Surge	Design	☐				Folio/Program	Doc/Data	☐				Grain	Equip/Tooling	☐	Supplier	☐	Cracks	Weld	Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	Wrong Stock Pulled	Material	☐	Use for Testing	☐	Cuffs	Out of Sequence	Internal Transport	☐	Poor Information	☐	Crushing	Off-set	Tribal Knowledge	☐	Rushing	☐	Heat Treat	Mislabeled	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	Fit/Function	Substation	☐	Process Improvement	☐	Marks/Chatter	Misaligned/off center	Past Expiry Date	☐	Manufacturing Process	☐			Misidentified	☐	Past Due	☐	OTHER :	
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Part Specifications
Specifications could not be found.

Plex 9/12/18 1:24 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

5.0 PARTS LIST

The parts list for D500-572-011/-021 Bearpaw Kits are updated as follows:

Qty -011	Qty -021	Part Number	Description
X		D500-572-011	BEARPAW INSTALLATION
	X	D500-572-021	NARROW BEARPAW INSTALLATION
2		D2435	BEARPAW
	2	D2671	BEARPAW
8	8	D2274	RADIUS BLOCK
8	8	D2529	WASHER
4	4	D5472-1	CUSHION (REPLACES D2182B050)
4	4	D5476-1	CLAMP (REPLACES D2438)
8	8	AN4-13A	BOLT (WAS AN4-15A)
8	8	NAS1149D0463J	WASHER (OR AN960JD416)
8	8	MS21042L4	NUT (OR MS21042-4)
2	2	QS200M44S	CLAMP

Operators who wish to upgrade their existing D500-572-011/-021 Bearpaw Kits in service can procure the DSI 9770-011 Clamp Kit from DART:

Qty -011	Part Number	Description
X	DSI 9770-011	BEARPAW INSTALLATION
8	D2274	RADIUS BLOCK
8	D2529	WASHER
4	D5472-1	CUSHION
4	D5476-1	CLAMP
8	AN4-13A	BOLT
8	NAS1149D0463J	WASHER (OR AN960JD416)
8	MS21042L4	NUT (OR MS21042-4)
2	QS200M44S	CLAMP

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 17.01.09
CERT. NO.: SH90-17
ISSUE NO.: 7

APPROVED

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	MB	
CHECKED	ML	DRAWING NO.
MFG. APPR.	N/A	DSI 9770
APPROVED	HS	TITLE
DE APPR.	DS	CLAMP KIT
DATE	17.01.09	SCALE
		NTS

REV. A
SHEET 2 OF 3

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Change Record

PAGE 1 OF 1

Part Number: D500-572-011

Description: BEARPAW INSTALLATION (500/520)

[illegible]